

Work Order ID 55522

January 19, 2010 2:55:26 PM



Page 1

Item ID: D2512

Accept



Setup Start



Revision ID:

Item Name: Basket Lid 205/350

Stop



Start Date: 1/20/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 1/25/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-1-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2512

Rev E

100



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: 4109213 0.00

Large Fab

Memo

0.00

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512 PD
2-Cut (4) D2236 From D3166-3 PD
3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305 PD
4-Weld as per Dwg D2512 using Welding Jig DT 9436
Deburr as required
INSTALL D2012-117 CLEVIS ONLY ON D130-701-041

SY 10/01/26



110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.00

10/04/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID:	D2512	Accept		Setup	Start	
Revision ID:						
Item Name:	Basket Lid 205/350				Stop	
Start Date:	1/20/2010	Start Qty:	1.00			
Required Date:	1/25/2010	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
	HandFinishing								
HandFinish	Memo	0.00							
Hand Finishing	Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4								
	Batch: <u>M113 545</u>								
150		0.00							
	QC3- Inspect Part Finish								
QC	Memo	0.00							
Quality Control									
160		0.00							
	Identify as per dwg & Stock Location: <u>GA</u>								
Packaging	Memo	0.00							
Packaging									

⇒ M/L 10/01/28

(IX)

GB 10/01/28 (U)

GB 10/01/28 (U)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Accept



Setup Start



Revision ID:

Stop



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Start Date: 1/20/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 1/25/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

6/10/28

ME 10-1-28

Dart Aerospace Ltd

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Picklist Print

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Page 1

Work Order ID: 55522

Parent Item: D2512

Parent Item Name: Basket Lid 205/350

Start Date: 1/20/2010

Required Date: 1/25/2010

Comments: Rev IPP:M 03.01.31 Added D2012-117 for D130-701-041 KJ/RF
 IPP Rev:N 06.04.05 Added level21 EC
 IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC
 IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D2012-117 Manufactured No 100 Each 14.0000 2.0000
 Clevis

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	14	
31101	2	
52498	12	N/A

ONLY APPLICABLE ON D130-701-041

D2232-1 Manufactured No 100 Each 8.0000 2.0000
 Basket Hinge

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	2	
48230	2	
Main Warehouse		
WA	6	
51105	6	2x

10/01/21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC
 IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Date: 1/20/2010

Required Date: 1/25/2010

Start Qty: 1.00

Required Qty: 1.00

D2327-1



Spacer Bushing

Manufactured No 100 Each 43.0000 2.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 43

52832 23

54658 20

✓

2x 10/01/21

D2506



Label Plate

Manufactured No 100 Each 5.0000 1.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 1

44275 1

Main Warehouse

WA 4

54136 4

✓

1x 10/01/26

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Shop Packet Print

Page 2

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 IPP Rev:N 06.04.05 Added level21 EC
 IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC
 IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D2581 Manufactured No 100 Each 49.0000 2.0000



Mounting Bracket



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 46

46086 2

48428 1

51120 2

54862 41

Main Warehouse

WA 3

50872 1

51745 2

2x *SM* 10/01/01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 IPP Rev:N 06.04.05 Added level21 EC
 IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC
 IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

D3166-3 Manufactured No 100 Each 13.1028 1.0000



Basket Hoop



Warehouse Loc Qty Loc Code

Location

Main Warehouse

53494

2.102775

53494

2.102775

PD 10.01.21

Main Warehouse

ST

5

48429

5

Main Warehouse

WA

6.000014474

52058

1.4474E-05

54018

6

M304EX0.75-16F

Purchased

No

100

sf

1,152.577 18.9474



Expanded Metal Flat SS



SAP 10.01.21

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

1152.577006

110134

3.4

111956

0.000017

112147

9.4736E-06

112949

38.00248

113205

0.0093

113497

292.8421

113555

818.3231

18.9474

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Page 4

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IPP Rev:N 06.04.05 Added level21 EC
IPP Rev:O 08-08-29 revE as per dwg DD verified by:EC
IPP Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

M304TS0.750W.065

Purchased

No

100

f

457.3833

45.8741



304 SQ Tube .75x.75x.065W

✓

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

457.3832742

113082

0.00419

113245

157.379084

113683

300

Main Warehouse

WA

0.0000047

112398

0.0000047

PD 10.01.21

January 19, 2010 2:55:26 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
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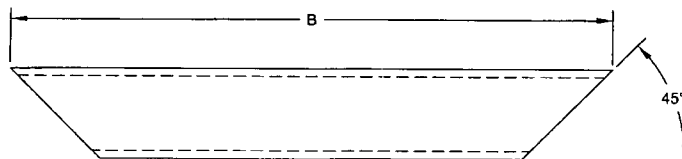
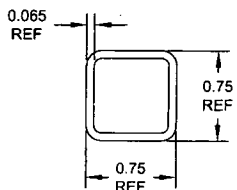
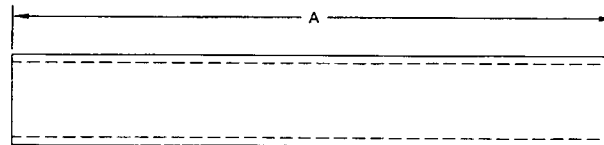
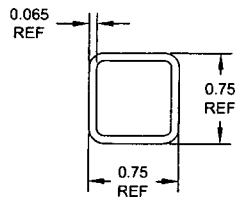
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PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET

#55522



RELEASED

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA D2512 BASKET LID ASSEMBLY (350/212) 08.06.17	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		REV. E SHEET 1 OF 4 SCALE NTS	
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY REPRODUCTION WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

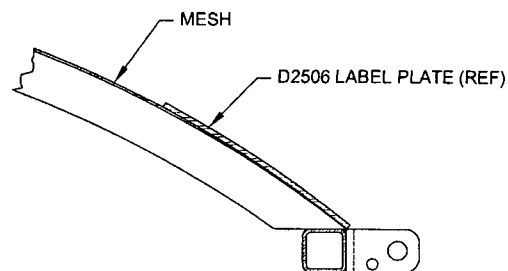
W/O:		WORK ORDER CHANGES					
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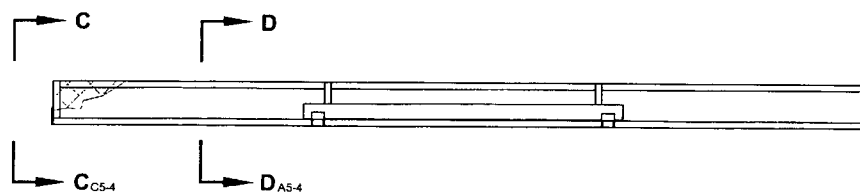
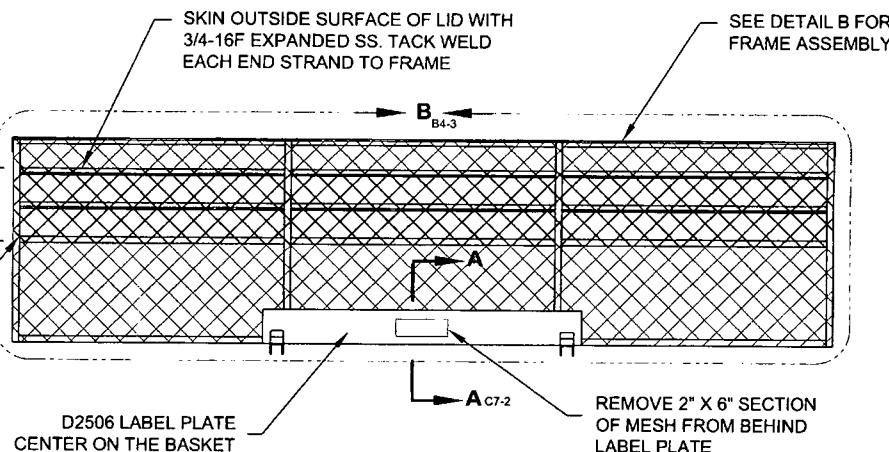
NOTE: Date & initial all entries



SECTION A-A_{B3-2}
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED



D2512 BASKET LID ASSEMBLY NOTES:

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

RELEASED
05.08.21/11

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

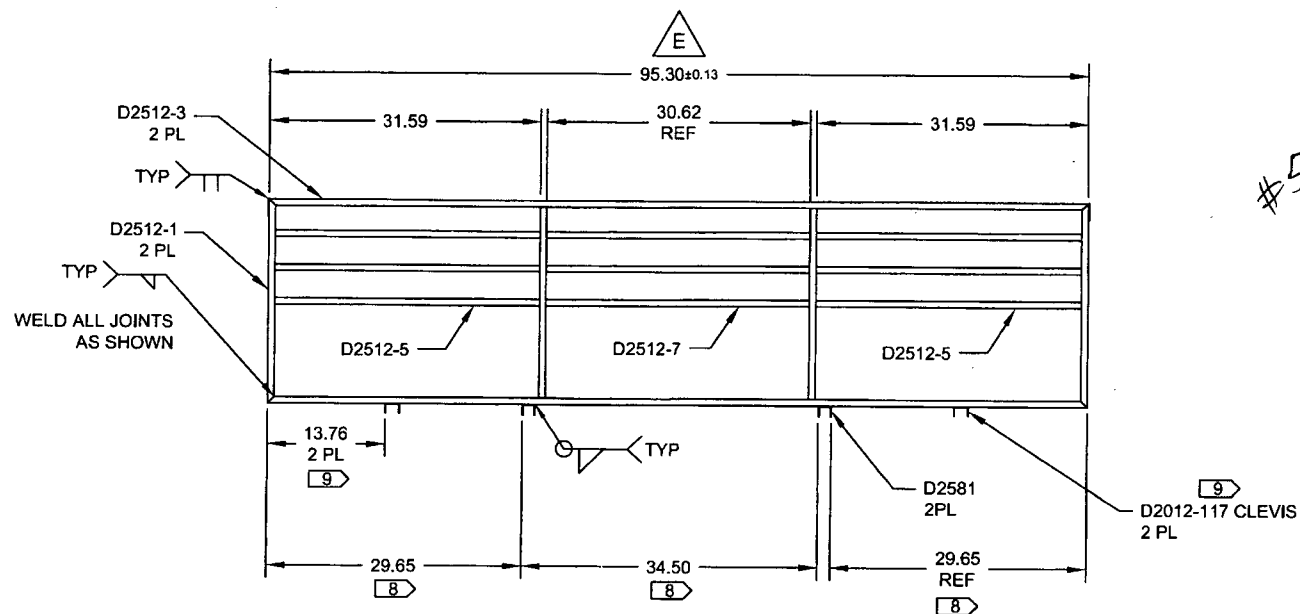
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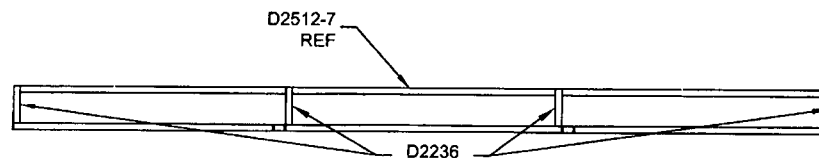
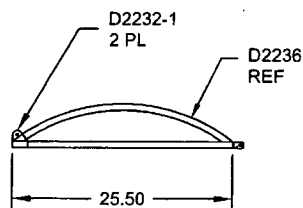
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DETAIL B C3-2
FRAMEWORK ONLY SHOWN FOR CLARITY



NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
- 9) FOR D130-701-041 ONLY

RELEASED
08 06 17

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	J	D2512	SHEET 3 OF 4
APPROVED	J	TITLE	SCALE
DE APPR.	J	BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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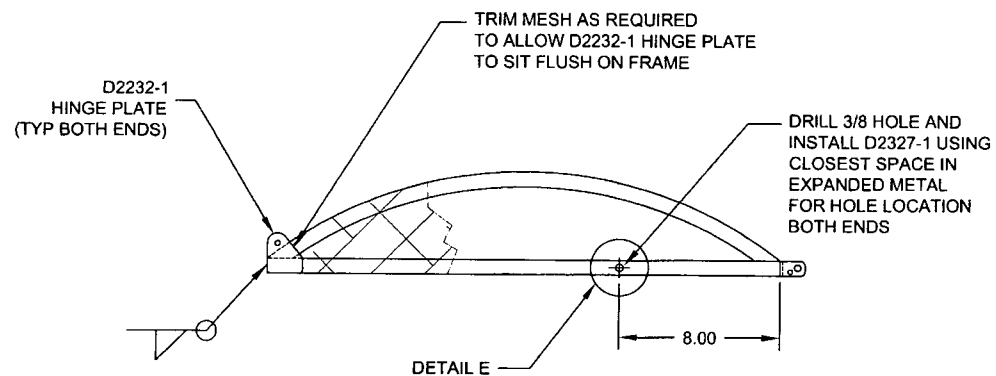
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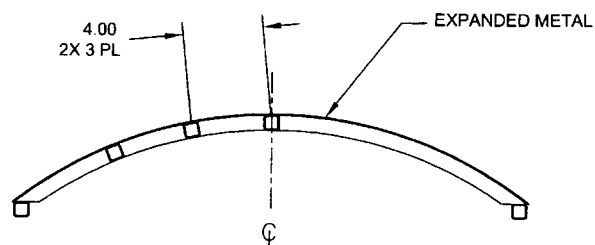
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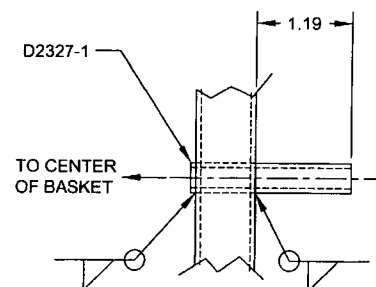
8 7 6 5 4 3 2 1



VIEW C-C SIMILAR BOTH END RIBS A5-2



SECTION D-D SAME BOTH CENTER RIBS A4-2



DETAIL E C6-4

RELEASED
08-06-17

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries